

Work Order ID 75078

October-17-11 10:50:30 AM

75078

Page 1

Item ID: D2731-7 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Mounting Lug
 Start Date: 17/10/2011 Start Qty: 50.00 ***50*** Cust Item ID:
 Required Date: 28/10/2011 Req'd Qty: 50.00 ***50*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/10/17 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2731	Rev C								

100 BAND SAW 0.00
100
 Bandsaw Memo 0.00 CZ 11/10/17
 Jeaspa Bandsaw Cut D2423 extrusion to .82" Batch _____

cut @ meter

110 HAAS CNC VERTICAL MACHINING #1 0.00
110
 HAAS 1 Reuch Memo 0.00 CZ 11/10/17 50
 HAAS CNC vertical machine #1 1-Machine as per folio FA930
 DWG REV: _____
 FOLIO REV: _____

issue P/O to meter P/O: 15174

2-Check for crack while loading into the machine machine as per drawing D 2731-7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

75078

Page 4

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

50

50

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

Quality Control

0.00

11/11/02

ME 11-11-0

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

October-17-11 10:50:34 AM

Page 1

Work Order ID: 75078

75078

Parent Item: D2731-7

D2731-7

Parent Item Name: Mounting Lug

Start Date: 17/10/2011

Required Date: 28/10/2011

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP D00.05.19Added inspect level 8, removed P/O powder coatingEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2731-7P		Purchased	No			100	Each	0.0000	1	50			
D2731-7P									**				
LUG													
D2423		Manufactured	No			110	f	505.7300	0.0683	3.594737			
D2423									**				
Lug Extrusion													

CL 11/10/11 ✓

Location

Loc Qty

Loc Code

MAT006

505.73

43722

161.5

45800

1

68331

343.23

3.60

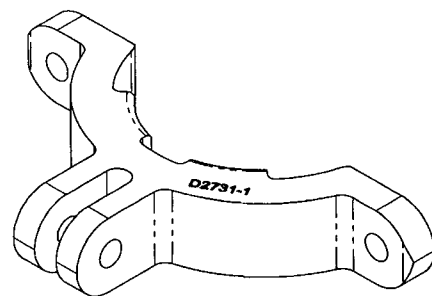
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

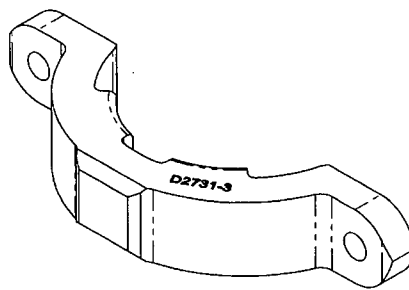
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

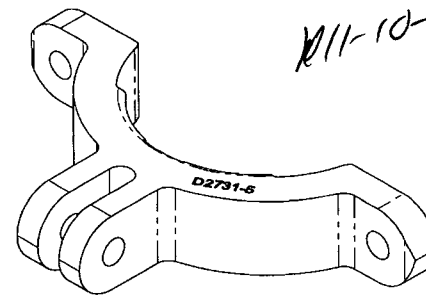
NOTE: Date & initial all entries



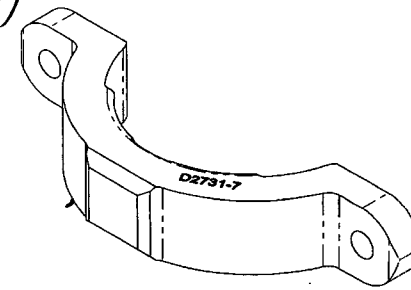
D2731-1 MOUNTING LUG



D2731-3 MOUNTING LUG



D2731-5 MOUNTING LUG



D2731-7 MOUNTING LUG

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 75028

11-10-17

DEO ATTACHED
RELEASED
09/01/99

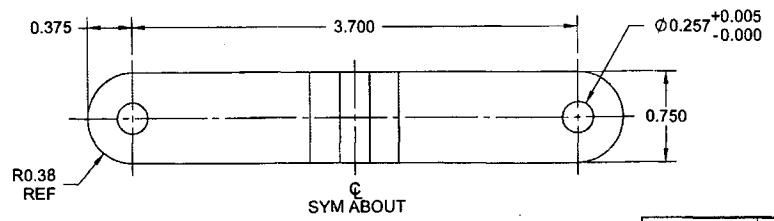
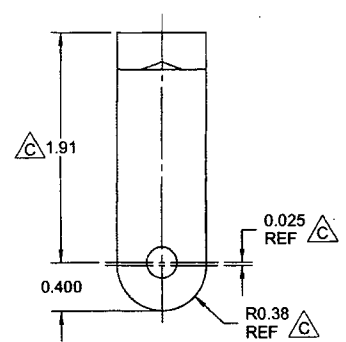
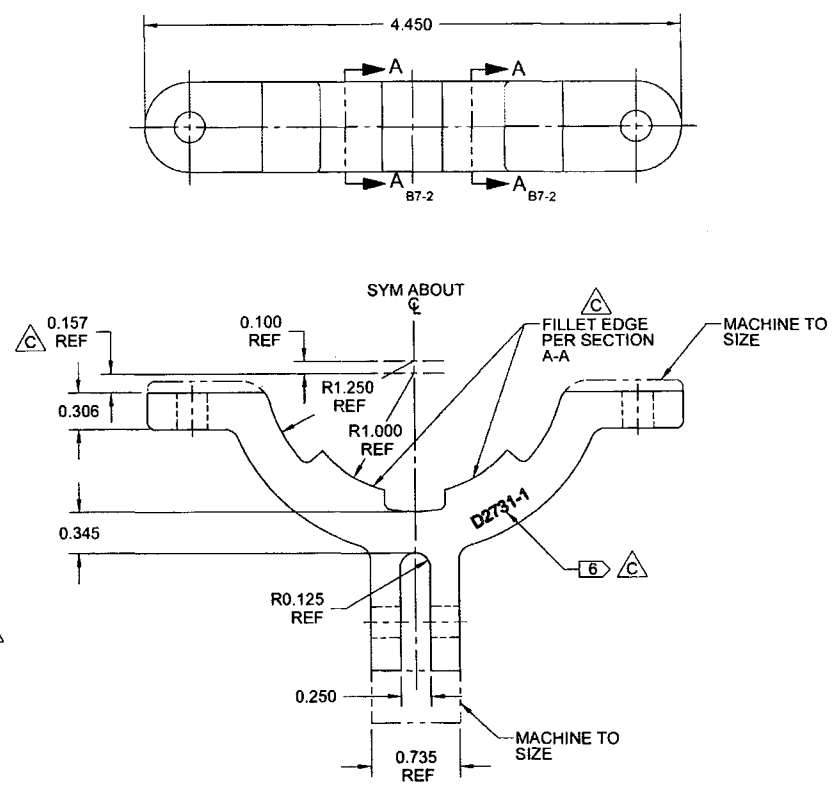
NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 ± 0.005.
- 7) WEIGHT: -1: 0.17 lbs
-3: 0.15 lbs
-5: 0.16 lbs
-7: 0.14 lbs

C	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A, B-B, C-C & D-D FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION.	AJS	09.01.19
B	REVISED DIMENSIONS	KE	99.07.06
A	NEW ISSUE	KE	98.05.13
REV.	DESCRIPTION	BY	DATE
DESIGN	KE	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2731	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
DATE	09.01.19	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

SECTION A-A D4-2
SCALE 2X

R0.06 MIN-R0.10 MAX
2 PL

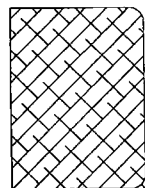


D2731-1 MOUNTING LUG

7507d

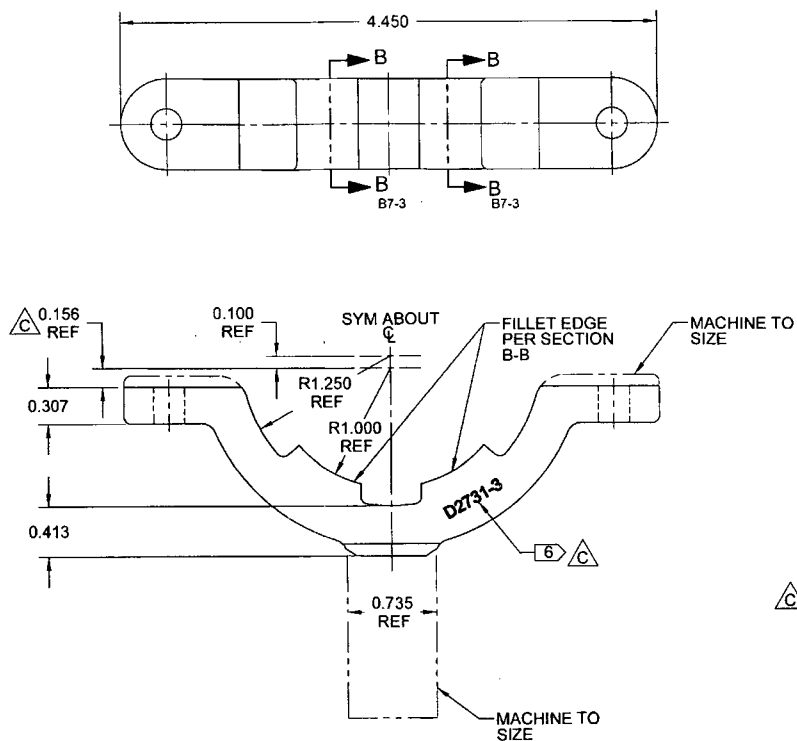
DEO ATTACHED
RELEASED
09/06/25/44

DESIGN	KE	DART AEROSPACE USA, INC.	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2731	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
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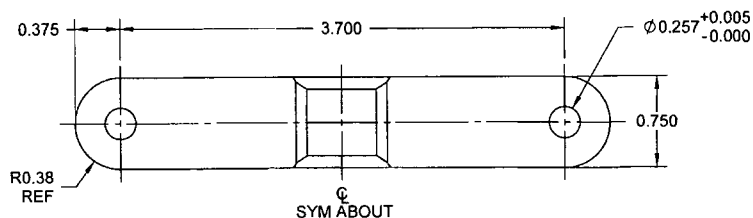
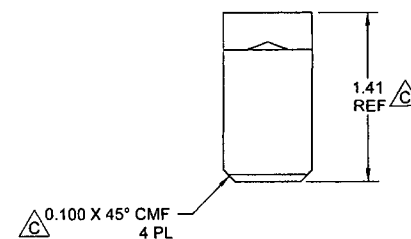


R0.06 MIN-R0.10 MAX
2 PL

SECTION B-B D4-3
SCALE 2X







75078



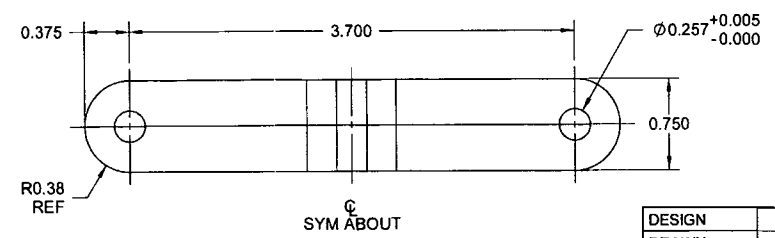
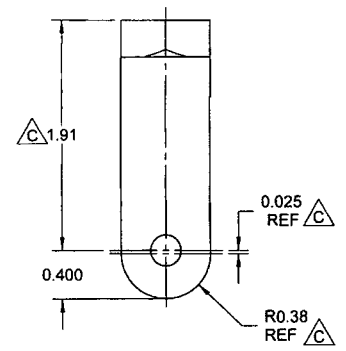
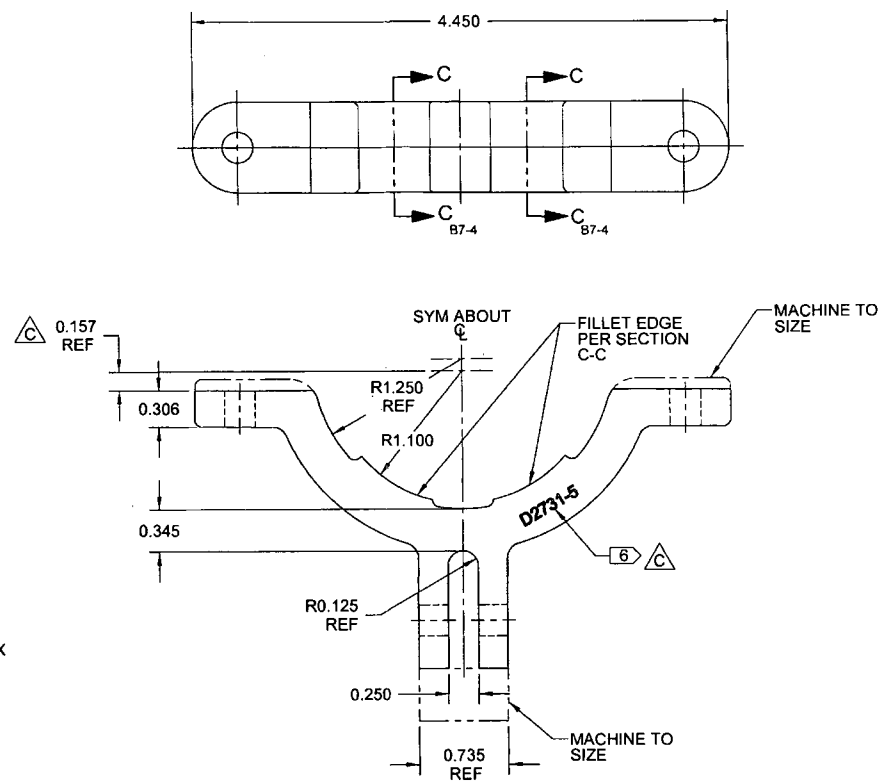
D2731-3 MOUNTING LUG

DEO ATTACHED
RELEASED
09/06/25

DESIGN	KE	DART AEROSPACE USA, INC.	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2731	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
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75078

SECTION C-C D4-4
SCALE 2X
R0.06 MIN-R0.10 MAX
2 PL

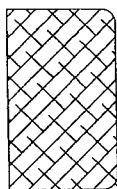


D2731-5 MOUNTING LUG

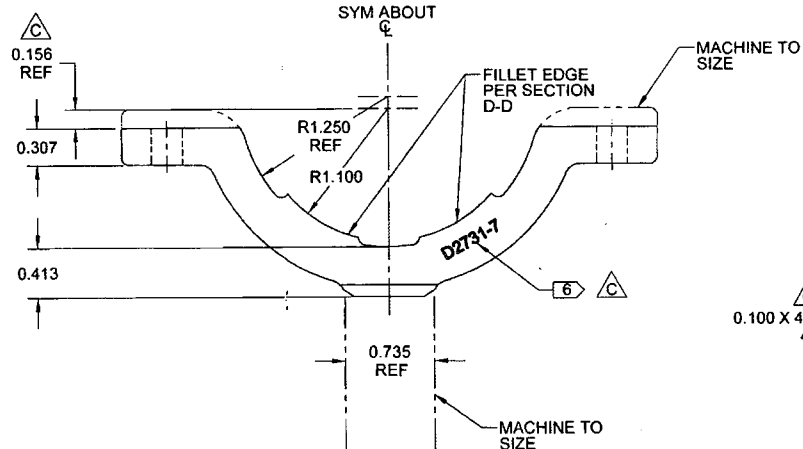
**DEO ATTACHED
RELEASED**
9/16/75 M

DESIGN		KE		DART AEROSPACE USA, INC.			
DRAWN		AJS		PORT HADLOCK, WA			
CHECKED				DRAWING NO.		REV. C	
MFG. APPR.				D2731		SHEET 4 OF 5	
APPROVED				TITLE		SCALE	
DE APPR.				MOUNTING LUG		NTS	
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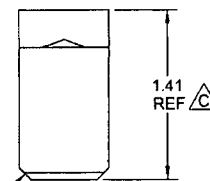
SECTION D-D D4-5
SCALE 2X



R0.06 MIN-R0.10 MAX
2 PL



0.100 X 45° CMF
4 PL



**DEO ATTACHED
RELEASED**
09/06/25/11

D2731-7 MOUNTING LUG

DESIGN	KE	DART AEROSPACE USA, INC.	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2731	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
DATE	09.01.19	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

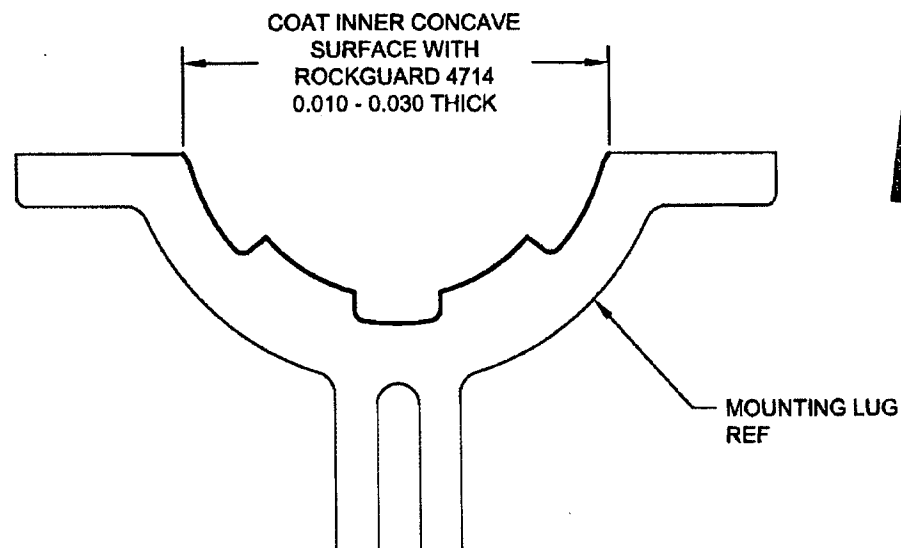
DRAWING NO. D2731	TITLE MOUNTING LUG	REV. C	DART AEROSPACE USA, INC ENGINEERING ORDER	D.E.O. NO. D2731-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>qp</i>	CHECKED <i>sc</i>	MFG. APPR. <i>MA</i>	APPROVED <i>MD</i>	DE APPR. <i>MD</i>		
DATE 11.05.02	DATE 11.05.09	DATE 11.05.09	DATE 11.05.09	DATE 11.05.09		

PURPOSE

ADD D2731-xRG OPTION

CHANGE

D2731-xRG MOUNTING LUGS ARE IDENTICAL TO D2731-x MOUNTING LUGS, HOWEVER AFTER FINISH, COAT INNER CONCAVE SURFACE WITH "PLUS ONE ROCKGUARD 4714" AS SHOWN BELOW.



D2731-1RG MOUNTING LUG (SHOWN)
D2731-3RG/-5RG/-7RG MOUNTING LUGS (SIMILAR)

RELEASED
2011-05-24
MD



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

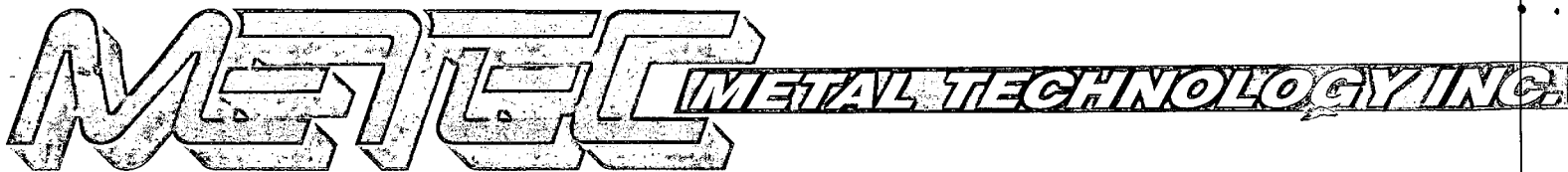
Delivery Slip No.: 18246
Date: Oct 24, 2011
Page: 1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 15174	Sold By: Dewar, Eric
Shipped By: your truck	Ship Date: Oct 24, 2011

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2731-7 LUG Material supplied by DART: D2423 B68331 as per drawing D2731 Rev.C B75078	Each	50	50	
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.				

Received by _____

Thank you for your order!



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
50	D2731-7P	Crosstube Lug	15174

MATERIAL: supplied by DART D2423 B68331

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Shigi Walz

Vankleek Hill, October 24, 2011